



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4445-1

Job Sheet 175970



Part No: D4445-1

Job Qty: 8 ea

Part Name: Cable Guard



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/13/18

Job Tracking No:

Due Date: 5/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A ALL SHEETS IPP REV:A 11/10/05 NEW ISSUE JFS VERIFIED BY:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		5/3/18	0.00	0.00	Start Up Machining-3		pc 18/04/18
100	Bandsaw	8 pcs		5/3/18	0.00	0.01	Bandsaw1		pc 18/04/18
110	QC	8 pcs		5/3/18	0.00	0.00	QC2 Machining-3		ct 18-04-26
120	CNC Vertical Machining	8 pcs		5/4/18	0.58	13.11	HAAS1-5		kt 18-04-26
130	QC	8 pcs		5/4/18	0.00	0.00	QC2 Machining-3		kt 18-04-26
140	QC	8 pcs		5/4/18	0.00	0.00	QC8 Machining-3		kt 18-05-02
150	Packaging	8 pcs		5/4/18	0.00	0.00	Packaging3-2	5260B	6 MAY 02 2018
160	QC21-SA	8 Ea		5/4/18	0.00	0.00	QC21		3-89 DAS MAY 02 2018

Part Op 100 - CUT TO 77.8" LONG

Descriptions: 120 - 1-Mill as per folio EB072 & dwg D4445, DWG REV: _____
140 - ENSURE D4445-1 IS MACHINE TO LENGTH AS PER DWG.

2" wide

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB1.750X1.000X96.00	MUHMWB1.75X1.00X96.00 (Tolerance +/- .010)	51.8400 ft (6.48 ea)	90-Start up Operation	

MUHMWB10

5045595

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB1.750X1.000X96.00	52	70	0

Part Specifications

Specifications could not be found.

Plex 4/13/18 7:20 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																							
Date : _____		Step #: _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																					
DART Aerospace Ltd. 1270 Aberdeen Street Markham, ON L6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S062497 Part: D4445-1 Job No: 175970 Serial No/Batch: S062497 Revision: Inspector: Date: 04/18/18																																																																																									
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DART AEROSPACE LTD	Work Order:	175931
Description: Cable Guard	Part Number:	D4445-1
Inspection Dwg: D4445 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.04	+/-0.030	2.038	✓		vernier	
10.23	+/-0.030	10.240	✓		tape	
18.41	+/-0.030	18.410	✓			
26.60	+/-0.030	26.60	✓			
34.79	+/-0.030	3.78	✓			
39.35	+/-0.030	39.35	✓			
42.98	+/-0.030	42.99	✓			
51.16	+/-0.030	51.16	✓			
57.60	+/-0.030	57.60	✓			
59.35	+/-0.030	59.35	✓			
68.01	+/-0.030	68.01	✓			
74.85	+/-0.030	74.85	✓			
76.60	+/-0.030	76.60	✓			
77.80	+/-0.030	77.80	✓		tape	
0.58	+/-0.030	0.575	✓		high gage	
1.44	+/-0.030	1.465	✓		vernier	
2.94	+/-0.030	2.947	✓		vernier	
27.51	+/-0.030	27.510	✓		tape	
40.25	+/-0.030	40.260	✓			
43.88	+/-0.030	43.88	✓			
60.03	+/-0.030	60.03	✓			
0.56	+/-0.030	0.564	✓		vernier	
65.10	+/-0.030	65.10	✓		tape	
68.88	+/-0.030	68.90	✓		tape	
0.52	+/-0.030	0.525	✓		vernier	
77.25	+/-0.030	77.260	✓		tape	
77.80	+/-0.030	77.80	✓		tape	
0.45	+/-0.030	0.455	✓		vernier	
0.95	+/-0.030	0.930	✓		high gage	
0.78	+/-0.030	0.780	✓		vernier	
0.70	+/-0.030	0.697	✓		vernier	
R2.00	+/-0.030	R2.00	✓		Gabert	
0.20 x 45°	+/-0.030 x +/-0.5°	0.215 x 45°	✓		vernier	
Ø0.437	+0.006/-0.001	0.437 Ø	✓		Ring gage	
Ø0.87	+0.010/-0.001	0.872 Ø	✓		vernier	
Ø0.75	+0.008/-0.001	0.749 Ø	✓			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

DART AEROSPACE LTD		Work Order: 175921
Description: Cable Guard		Part Number: D4445-1
Inspection Dwg: D4445 Rev: A		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.60	+/-0.030	.610	✓			
Ø0.88	+0.010/-0.001	.880	✓			
0.37	+/-0.030	.376	✓		Vernier	
0.64	+/-0.030	.635	✓		Vernier	
Ø0.850	+0.010/-0.001	.850 Ø	✓		Pin gage	

Measured by: M. V. M.	Audited by: D. P.	Preliminary Approval:
Date: 2018/04/25	Date: 18-05-02	Date:

Rev	Date	Change	Revised by:	Approved
A	14.09.22	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					